November 23, 2009 11:24:17 AM Item ID: D2583

Required Date: 27/11/2009

В

Revision ID: Item Name:

Start Date:

Latch Bracket

23/11/2009

QC:

Start Qty: 20.00

Req'd Qty: 20.00

Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date 09-11-23

Tooling: SPC (Y/N):

Accept

Run

Start

Stop

Setup Start

Stop

Sequence ID/ Work Center ID

Draw Nbr

Operation Description

Revision Nbr

Set Up/ **Run Hours** Draw Number

Draw Rev.

Date:

Date:

Plan Accept Qty Code

Reject **Qty**

Reject Number

Insp. Stamp

D2583

Rev B

100

Waterjet

FLOW CNC Waterjet

erry

FLOW WATER JET

Deburr if necessary

□Prog Rev: \

139-17-

110

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

0.00

Quality Control

Memo

0.00

B 9-12-

120

QC8- Inspect parts - second check

27 807/12/07

Memo

Quality Control

Dart	Aer	OS	pace	Ltd
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	- **	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			:			**			
Part No	:	PAR #:	Fault Cateç	jory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	1:	_ QA: N/C (Closed:		Date:	
NCR:		\	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	CTED	Description of NC	Description of NC Corrective		\ \ \ \ \ \ \ \ \ \ \ \			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	on C	Chief Eng	QC Inspector
	,								
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					·				

Work Order ID 53889



Page 2

November 23, 2009 11:24:17 AM

В

Item ID:

D2583

Accept

Setup Start

Stop

Revision ID: Item Name:

Start Date:

Latch Bracket

Required Date: 27/11/2009

23/11/2009

Start Qty: 20.00

Reg'd Qay: 20.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____ Tooling:

SPC (Y/N):

0.00

0.00

Date:

Date:

Start Run

Stop

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation **Description**

NC BRAKE

Date:

Deburr□Form on CNC Brake as per Dwg D2583

Set Up/ **Run Hours** Draw Number

Spoalizhy

Plan Draw Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

32 8

QC5- Inspect part completeness to step on W/O

=> Soulisty 0.00

140

QC

Quality Control

Memo

Memo

Memo

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

K 09-12-14

Dart Aerospace Ltd	d	Lt	е	C	a	þ	S	O	er	A	rt	a	D
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	1244								
W/O:		The state of the s	W	ORK ORDER CHANGES					
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
, '									
					<i>J</i>				
]			144-7-1			<u> </u>		}
Part No	:	PAR #:	_ Fault Cate	egory: N	ICR: Yes	No DQ	A :	Date: _	
	R	esolution:	_ Disposition	on: (A: N/C Cld	sed:		Date: _	
NCR:		W	ORK ORD	ER NON-CONFORMAN	CE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section B		Verific	Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
							-		
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			1 1		1				ı

November 23, 2009 11:24:17 AM

Item ID:

D2583

В **Revision ID:**

Item Name:

Latch Bracket

Start Date:

23/11/2009

Start Qty: 20.00

Required Date: 27/11/2009

Req'd Qty: 20.00



Accept

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date: _____

Date:_____

Tooling:

Set Up/

Run Hours

SPC (Y/N):

Draw

Number

Date:

Draw

Rev.

Plan

Code

Date:

Run

Accept

Qty

Setup Start

Start

Stop

Stop

Reject

Reject

Qty



Number Stamp

Insp.

Sequence ID/ **Work Center ID**

160

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M112148

Memo

START TIME: 320 DFINISHTIME:

Identify as per dwg & Stock Location: 436000

0.00

0.00

Bl 0912-15

□OVEN TEMPERATURE:

10:50

170

Quality Control

QC3- Inspect Part Finish

Memo

0.00 => M 09-12-15

0.00

180

Packaging

mo 01/2/16

Packaging

Memo

0.00

Dart Aerospac	ce	Ltd
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	Johnson									
W/O:			Wo	RK ORDER C	HANGES			<u> </u>		
DATE	STEP	PRO	OCEDURE CHAI	NGE	je s	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·				, , , , , , , , , , , , , , , , , , ,	* Y					
Part No		PAR #:								
	Re	esolution:	Disposition	n:	Q	A: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CON	ORMANC	E (NCF	R)			
DATE	STEP	Description of NC		Corrective Action			Verific	cation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Desc Chief En	ription	Sign 8 Date	Secti		Chief Eng	QC Inspector
										,
<u> </u>										; }
				, , , ,						

Picklist Print

November 23, 2009 11:24:24 AM

Work Order ID: 53889

Parent Item:

D2583RevB

Parent Item Name: Latch Bracket

Comments:



Start Date: 23/11/2009

Required Date: 27/11/2009

Page 1

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.040	IIII	Purchased	No			100	sf	121.8000				***
											1-61-P SH	

5052-H32 .040 Sheet

Warehouse	Loc Qty	Loc Code	(32)
Location			
Main Warehouse			
MAT	121.8		\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \
101875	8.125		101875 × 12= 1.4766
102723	1		11\-\(\alpha\) L \(\beta\) .
104921	6.5		184937 2 5+4=1.107
106900	2		
107513	4.5		. 1230
109058	35.675		· (172A
113123	64		
107461			107461 × 8 = ,984

Dart Aerospace	e Ltd
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W/O:			N	ORK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca		NCI	R: Yes N	do DO	۸-	Date:	
		esolution:								
NCR:		,	WORK OR	DER NON-CONFORM	ANCE	(NCR))			
DATE	CTED	Description of NC	Corrective Action Section			Verificat			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
				•						
									:	
								<i>‡</i>		
								•		

DART AEROSPACE LTD	Work Order:	53889
Description: Latch Bracket	Part Number:	D2583
Inspection Dwg: D2583 Rev: B		Page 1 of 1

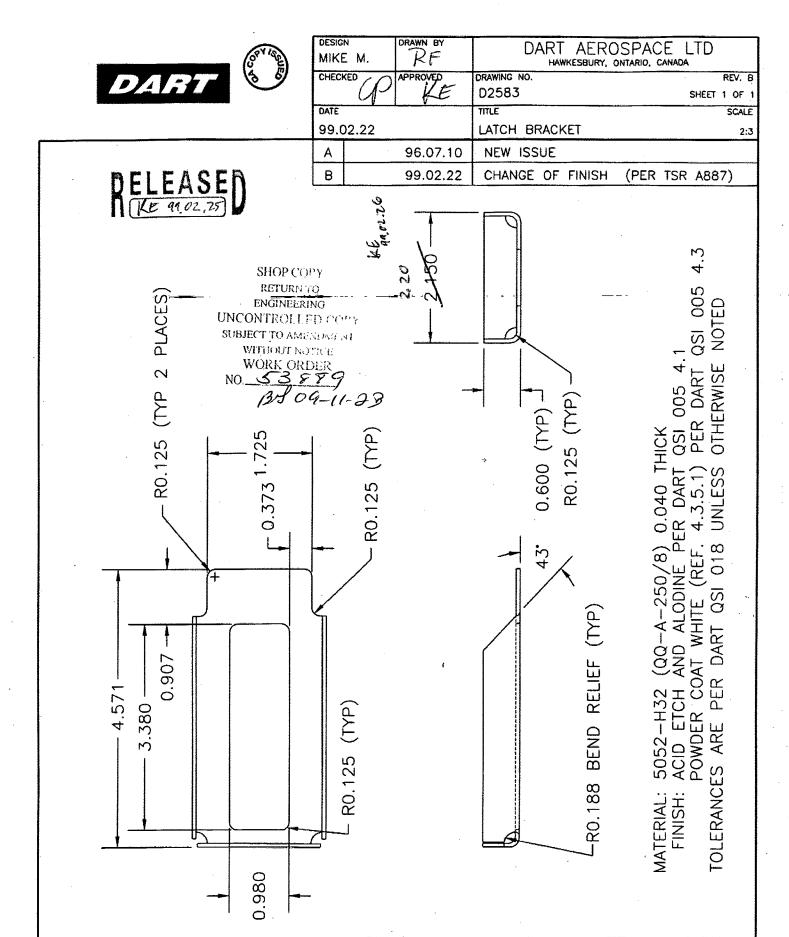
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.188	+/-0.010	3,185	d			
3.380	+/-0.010	3.384	y			
0.907	+/-0.010	· 906	>			
1.725	+/-0.010	1723	×			
R0.125	+/-0.010	175	8			
0.980	+/-0.010	,986	79			
			<u> </u>			
			-	7		
		•				
			-			
				-		

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 9-13-7	Date: 09/12/07	Date:	N/A

Rev	Date	Change	Revised by	Approyed
A	04.06.25	New Issue	KJ/JLM	<i>SM</i>



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